

Work Order ID 54799

December 22, 2009 1:24:18 PM



Page 1

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Item Name: Adapter

Stop



Start Date: 12/28/09 Start Qty: 20.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 09/12/23 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D3773 | Rev B |
|-------|-------|

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blank 2.700" long

ml 10/01/03

20 1

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA740 Rev: AA & Dwg D3773 Rev: B 12-Deburr
per dwg D3773

8/10/01/09

20 1

PTO

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

8/10/01/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3773-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: A Date: 10.01.12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: A Date: 10/01/26

| NCR: <u>54799</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|-----------------------------|---|------------------------------|-----------------------------|---------------------------|-----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/01/09 | 110 | On 3 rd operation the part move in the vise when machining. R.C. Part wasn't sit properly | <u>JD</u> <u>05/42</u> | Replace Batch # <u>112752</u> → Re made new Tooling DT 9570 | <u>JS</u> <u>10/01/09</u> | <u>S</u> <u>10/01/11</u> | <u>JD</u> <u>05/42</u> | <u>S</u> <u>10/01/11</u> |
| | | on parallel so I machined a solid Jaws. / Tooling | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Page 2

Item ID: D3773-1

Accept



Setup Start



Revision ID:

Item Name: Adapter

Stop



Start Date: 12/28/09 Start Qty: 20.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location 250A

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-01-11

20

10-1-11 sl 20x-

10/01/12

10-1-11

20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54799

Parent Item: D3773-1

Parent Item Name: Adapter

Comments:

Start Date: 12/28/09

Required Date: 1/08/10

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M304B1.500X1.500

Purchased

No

100

f

25.7300

4.7368



304 bar 1.50 X1.50

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

25.73

108381

13.23

→ 112752

12.5

4.7368 *not 10/01/03*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

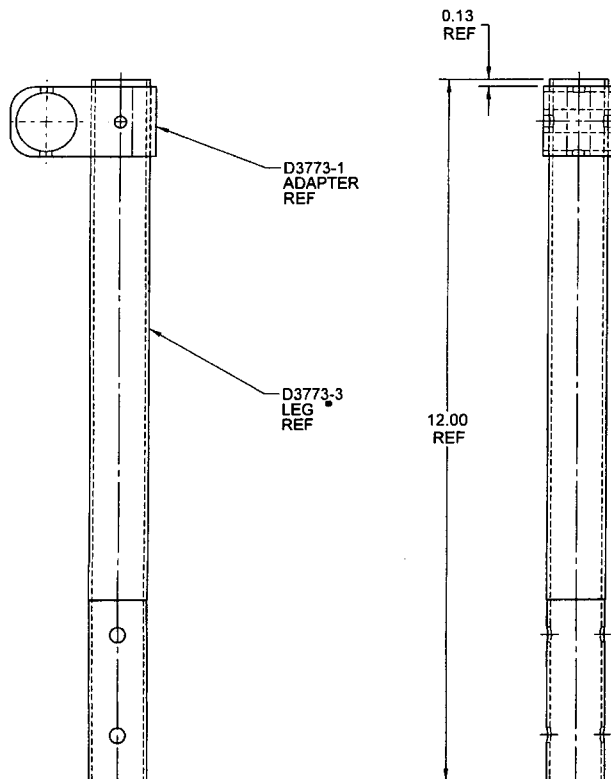
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D

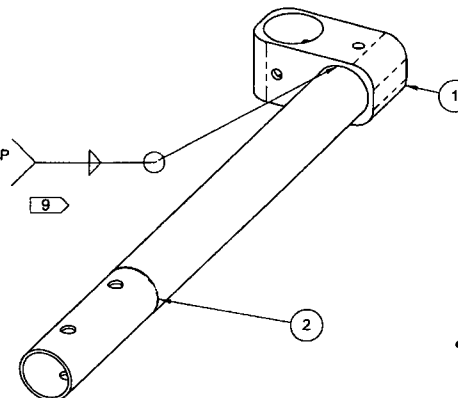
C

B

A



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C209112123



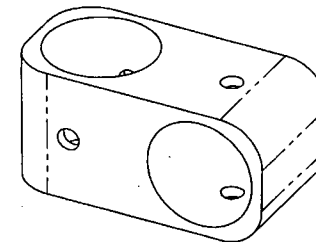
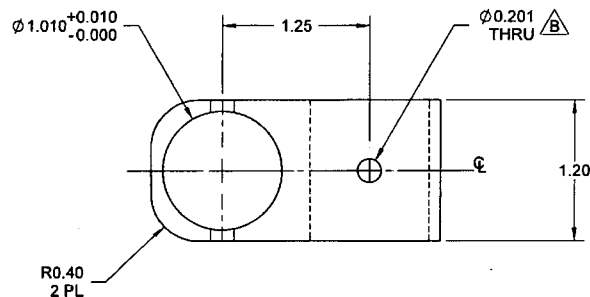
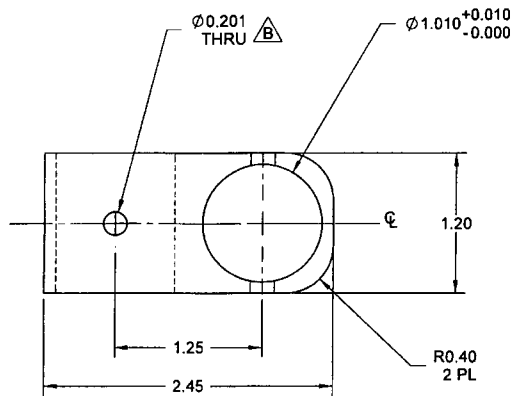
| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|----------|-------------|-------------|------|
| 1 | D3773-1 | ADAPTER | 1 |
| 2 | D3773-3 | LEG | 1 |

NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

| B | CHANGE HOLE SIZE TO 0.201 | HS | 08.06.24 |
|--|---------------------------|--------------|----------|
| A | NEW ISSUE | HS | 08.06.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | | |
| DRAWN | HS | | |
| CHECKED | PA | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.06.24 | | |
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| | | REV. B | 08.06.04 |
| | | SHEET 1 OF 3 | |
| | | SCALE | NTS |



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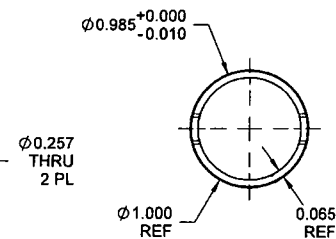
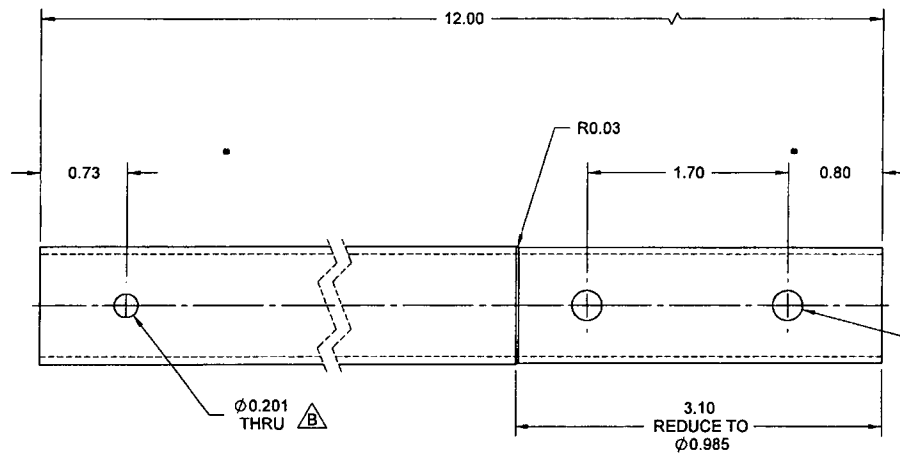
D3773-1 ADAPTER

RECEIVED
08-07-10

- NOTES:
1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.40 lbs

| | | | |
|------------|----------|--|--------------|
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| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3773 | REV. B |
| MFG. APPR. | | | SHEET 2 OF 3 |
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D3773-3 LEG

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

| | | | |
|------------|----------|--|--------------|
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| MFG. APPR. | | D3773 | SHEET 3 OF 3 |
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